



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3562-041
Job Sheet 173039



Part No: D3562-041

Job Qty: 1 ea

Part Name: Step Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A New Issue 06-11-09 JLM IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C ECN1048 07-12-18 DD verified by:ec IPP Rev:D 08-07-28 add chemical conversion coat DD ver:EC IPP REV:E 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23 AS PER DWG REV.G DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/19/18	0.00	0.00	Start Up Large Fab-4		DC 2018-03-05
100	Large Fab	1 pcs		3/19/18	0.00	1.48	Large Fab 8		Cpl 18-03-05
110	QC	1 pcs		3/19/18	0.00	0.00	QC5		Cpl
120	HandFinish	1 pcs		3/19/18	0.00	0.23	HandFinish1		SA 18-03-06
130	QC	1 pcs		3/19/18	0.00	0.00	QC7-2		Cpl
140	Small Fab	1 pcs		3/19/18	0.00	2.08	Small Fab-4		DC 2018-03-07
150	QC	1 pcs		3/19/18	0.00	0.00	QC5		Cpl
160	Large Fab	1 pcs		3/19/18	0.00	1.48	Large Fab 2		DC 18-3-7
170	QC	1 pcs		3/19/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs		3/19/18	0.00	0.00	QC5		9-88 38
190	HandFinish	1 pcs		3/19/18	0.00	0.23	HandFinish1		SA 18-03-08
200	Powdercoat	1 pcs		3/19/18	0.00	0.28	Powdercoat1		BL 18-3-13
205	SprayPaint	1 pcs		3/19/18	0.00	0.00	Spray Paint		
210	HandFinish	1 pcs		3/20/18	0.00	0.23	HandFinish3		EL 18-3-17
215	QC	1 pcs		3/20/18	0.00	0.00	QC3		38
220	QC	1 pcs		3/20/18	0.00	0.00			9-88
230	Packaging	1 pcs		3/20/18	0.00	0.00	Packaging3-1		Smb
240	QC21-SA	1 Ea		3/20/18	0.00	0.00	QC21		MAR 15 2018 P1002

Part Op 100 - 1-Cut D2622 extrusion as per Dwg D3562

Descriptions: 140 - 1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Scotch-Weld as per dwg D3562. *****Ensure to wipe off any excess magnobond ***** A/R Scotch-Weld DP460

Batch: M137679 EXP DATE: 6/18

160 - 1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024. 2-Grind end cap welds flush as per Dwg D3562

200 - START TIME: 8:15 OJT: 320° FINISH: 8:45 M 138760

205 - Prime Tempo Grey 4500-P-23 per QSI005 4.2.1.3.2

5047816

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	5046116
D2734	Step End Plate	2 Ea (2 ea)	140-Small Fab	5012001
D3560-041	Arm Weldment	1 Ea (1 ea)	140-Small Fab	5045608
D3560-043	Arm Weldment	1 Ea (1 ea)	140-Small Fab	5045580
MS20600-AD4W4	Rivet	32 Ea (32 ea)	140-Small Fab	5025738

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	8	0
140-Small Fab	D2734	2	27	0
	D3560-041	1	0	0
	D3560-043	1	0	0
	MS20600-AD4W4	32	1,841	0

Part Specifications				
Specifications could not be found.				

Plex 2/26/18 7:33 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	

Env
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DART
AEROSPACE

Container No: S047816
Part: D3562 - 041
Job No: 173039
Serial No/Batch: S047816
Revision:
Inspector:

Date: 03/05/18

Master Unit 001397

Job No 173039

Master Unit 001480

Job No 173039

OP: 140

start up op: 20